

Date: Monday, 03/11/2008 1:30:29 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STRUT		
Job Number	: 43164		Part Number	: D30841		
Estimate Number	: 11557		Drawing Number	: D3084 REV A		
P.O. Number	:		Project Number	: N/A		
This Issue	: 03/11/2008	S.O. No. :	Drawing Revision	: A		
Prsh Rev.	: NC		Material	:		
First Issue	: / /	Type : LARGE FAB ASSY	Due Date	: 15/11/2008	Qty:	6
Previous Run	: 26792		Um:	Each		
Written By	:					
Checked & Approved By	: <u>JUL 08-11-03</u>					
Comment	: Est. C 02.05.11 Added welding rod batch number NG					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	M6061T6T0750W058	6061-T6 RD Tube .750 x.058W	
		Comment: Qty.: 3.3249 f(s)/Unit Total : 19.9496 f(s) 6061-T6 Tube .750 x.058W Material: .750 Dia X .058 wall 6061-T6(ww-t-700/6)Seamless Aluminum tubing No: M10099	Batch: SB 08/01/08
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Punch per Dwg. D3084 and spec control dwg D2638 Open hole to .323Ø as per dwg, one side only Deburr	SB 08/01/08 M.F. 09/01/12
3.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	SP 09/01/13
4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1 Weld ends per QSI 004. Use aluminum rod Grind flush. Batch: M104855	M.F. 09/01/14 FF 09/01/14 SP 09/01/13
5.0	QC9	VISUAL WELDING INSPECTION	
		Comment: VISUAL WELDING INSPECTION	BF 09-01-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 03/11/2008 1:30:30 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 43164

Part Number: D30841

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/01/14 ✓7

7.0

POWDER COATING

POWDER COATING



M 109996

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

11:15am

OVEN TEMPERATURE:

320° =

FINISH TIME:

1:45am

11

09-01-15

✓7

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Fx 09/01/15

G

9.0

PACKAGING 1

PACKAGING RESOURCE #1



loc 271

7X
SO

Comment: PACKAGING RESOURCE #1

9/1/15

10.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/16 ✓8

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-01-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

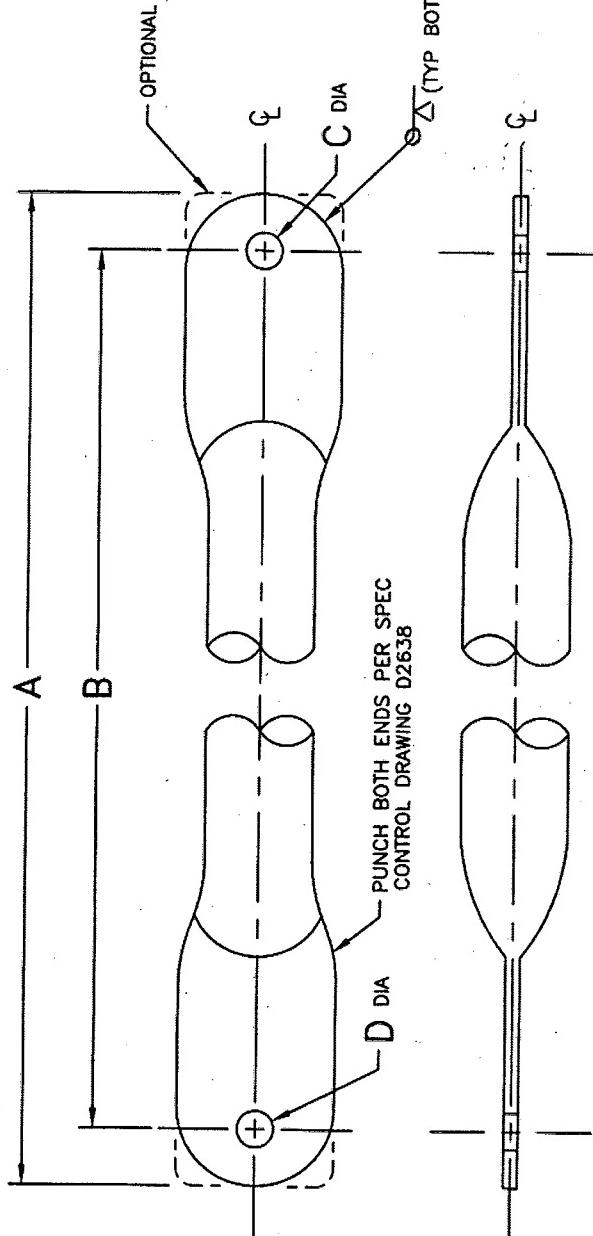


DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>✓</i>	APPROVED <i>✓</i>	DRAWING NO. D3084	REV. A SHEET 1 OF 1	
DATE 02.01.21		TITLE STRUT	SCALE NTS	
A	02.01.21	NEW ISSUE		

RELEASED
02.01.25

02.01.25



NOTES:

1. MAKE PER TEMPLATE DT3084-XX WHERE XX IS THE RESPECTIVE DASH NUMBER
 2. MATERIAL: 6061-T6 (W-W-T-700/6) SEAMLESS TUBE @0.750 x 0.058 WALL
 3. WELD ENDS PER DART QS 004 AND GRIND FLUSH
 4. FINISH: POWDER COAT WHITE (4.35.1) PER DART QSI 005 4.3
 5. TOLERANCES ARE PER DART QS 018 UNLESS OTHERWISE NOTED
 6. ALL DIMENSIONS ARE IN INCHES

~~NO. 4-164~~

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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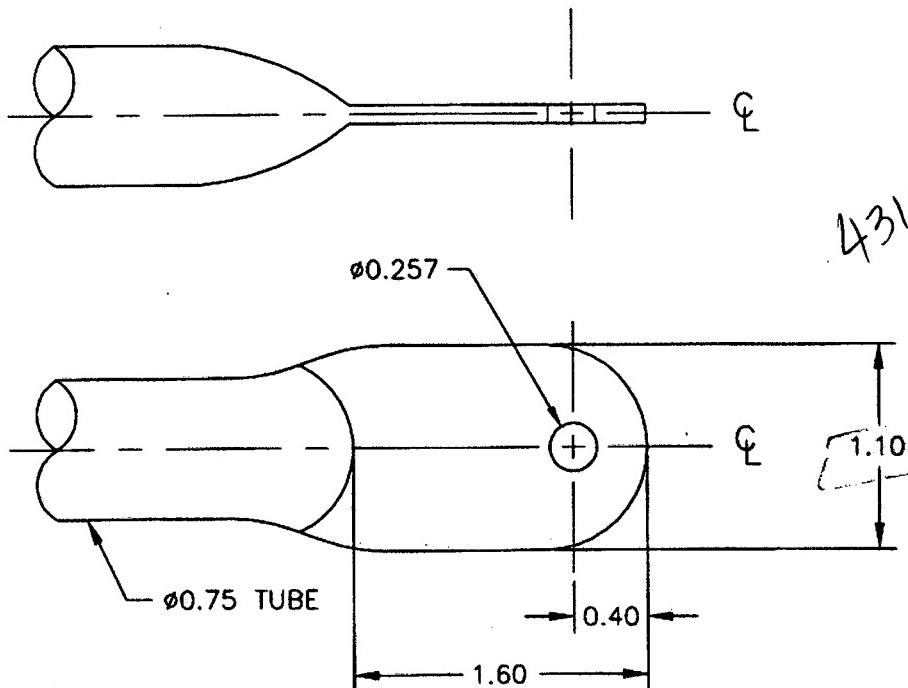
NOTE: Date & initial all entries

DART

DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED MM	APPROVED JF	DRAWING NO. D2638	REV. A SHEET 1 OF 1
DATE 98.04.28		TITLE PUNCH DT8117 SPEC CONTROL	SCALE 1:1
A	98.04.28	NEW ISSUE	

RELEASED
98/05/05 KE

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8117

**REFERENCE ONLY**

